

Date: Thursday, 16/10/2008 10:45:36 AM  
User: Julie Dawson

## **Process Sheet**

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services			<b>Drawing Name</b>	: BASKET BASE ASSEMBLY (350)			
<b>Job Number</b>	: 42630C							
<b>Estimate Number</b>	: 10189							
<b>P.O. Number</b>	:			<b>Part Number</b>	: D2221			
<b>This Issue</b>	: 16/10/2008	<b>S.O. No.</b>	:	<b>Drawing Number</b>	: D2221 REVG			
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A			
<b>First Issue</b>	: / /	<b>Type</b>	: LARGE FAB ASSY	<b>Drawing Revision</b>	: G			
<b>Previous Run</b>	: 42628C			<b>Material</b>	:			
<b>Written By</b>	:			<b>Due Date</b>	: 11/11/2008			
<b>Checked &amp; Approved By</b>	: <u>SD 08-10-16</u>				<b>Qty:</b>	1	<b>Um:</b>	Each
<b>Comment</b>	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC							

## **Additional Product**

Job Number:			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>		<b>Description :</b>
1.0	D31661	Basket Hoop	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick: Qty Part Number Description Batch 4 D3166-1 RIB <u>42716</u> SAN CP-11-1B ①			
2.0	D22323	Basket Hinge	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)			
Pick: Qty Part Number Description Batch ✓ 2 D2232-3 Hinge bracket <u>B39334</u> Mo8/11/17 ②			
3.0	D2325	Support Gusset (350 Basket)	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)			
Pick: Qty Part Number Description Batch ✓ 4 D2325 Support Gusset <u>2x B38741</u> Mo8/11/17 <u>3x B39913</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 42630C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 2 D2327-3 Bushing

B29560

Mo 08/11/17

5.0 D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 2 D2581 Mounting Bracket B40895

Mo 08/11/17

6.0 D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

✓ 2 D3442-1 Shim B40392

Mo 08/11/17

7.0 M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

✓ 39.69 sf M304EX0.75-16F Expanded Metal M109383

Mo 08/11/19

8.0 M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.065 wall 304/316 SStubing

Batch: M108846 (8)

M109731 (20.4)

SAB 08-11-13

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

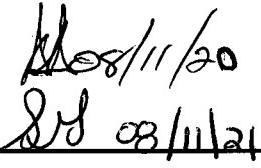
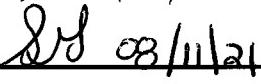
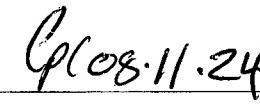
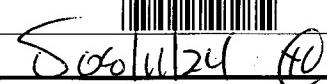
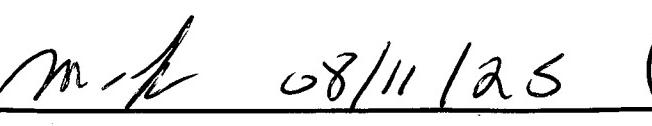
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 42630C		Part Number: D2221
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
9.0	LARGE FAB 1 	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235		
2-Drill hole in D2221-3 as per Dwg D2221		
3-Deburr		
4-Remove all markings on material before welding		
5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required		
 		
10.0	QC9 	VISUAL WELDING INSPECTION   
Comment: VISUAL WELDING INSPECTION		
11.0	QC6 	DIMENSIONAL CHECK   
Comment: DIMENSIONAL CHECK		
12.0	POWDER COATING 	POWDER COATING   
Comment: POWDER COATING		
1- Plug holes in D2581 prior to powder coating		
2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
1ST COAT: START TIME: <u>3:40</u> OVEN TEMPERATURE: <u>400</u> °F FINISH TIME: <u>4:10</u> ***** 2nd coat if necessary ***** 		
2ND COAT: START TIME: <u>7:30</u> OVEN TEMPERATURE: <u>400</u> °F FINISH TIME: <u>8:00</u> 		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 42630C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Sosu05 (x)

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 JF

Job Completion



JF 08-11-26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

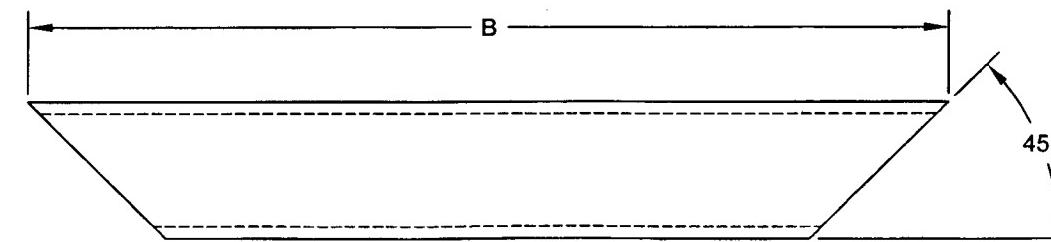
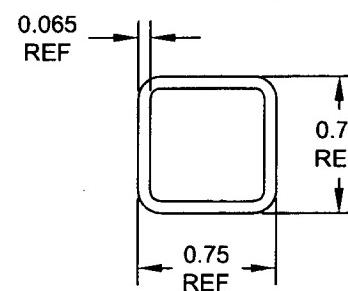
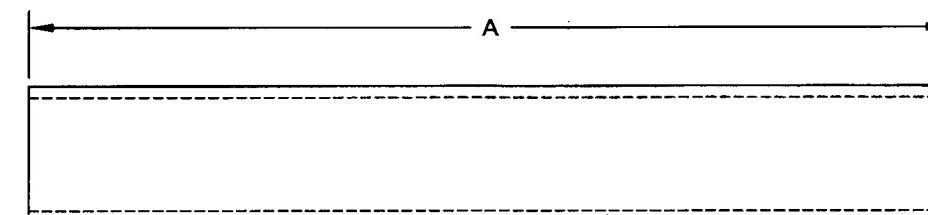
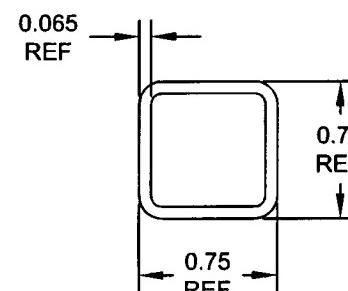
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

## PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	_____	96.00	RIB
D2221-3	2	_____	25.50	RIB
D2221-5	2	18.88	_____	RIB
D2221-7	1	55.25	_____	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	SHIM



D2221-1/3-5/7

1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL  
REF. DART SPEC M304TS0.750W.065

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

4) ALL DIMENSIONS ARE IN INCHES

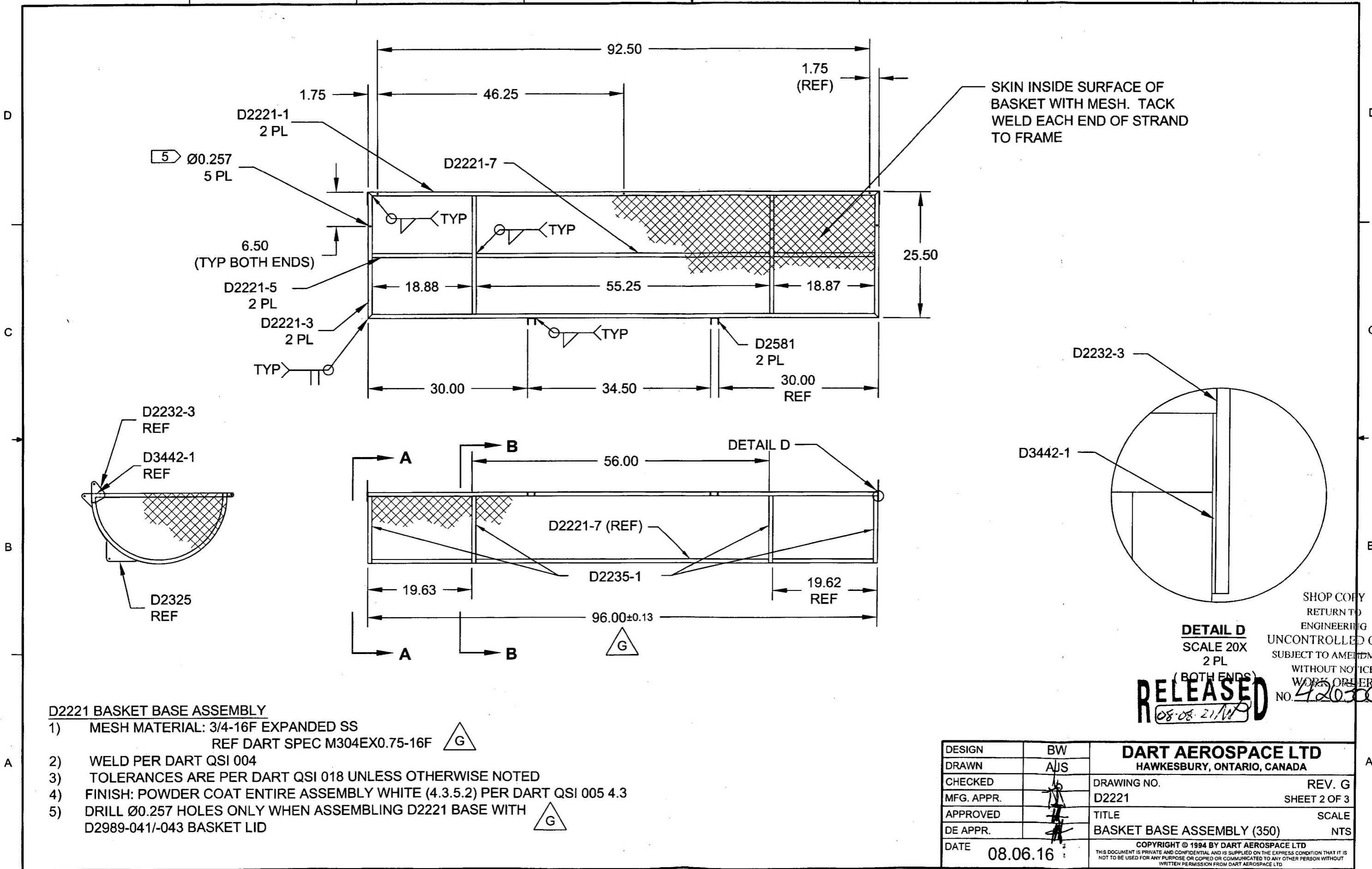
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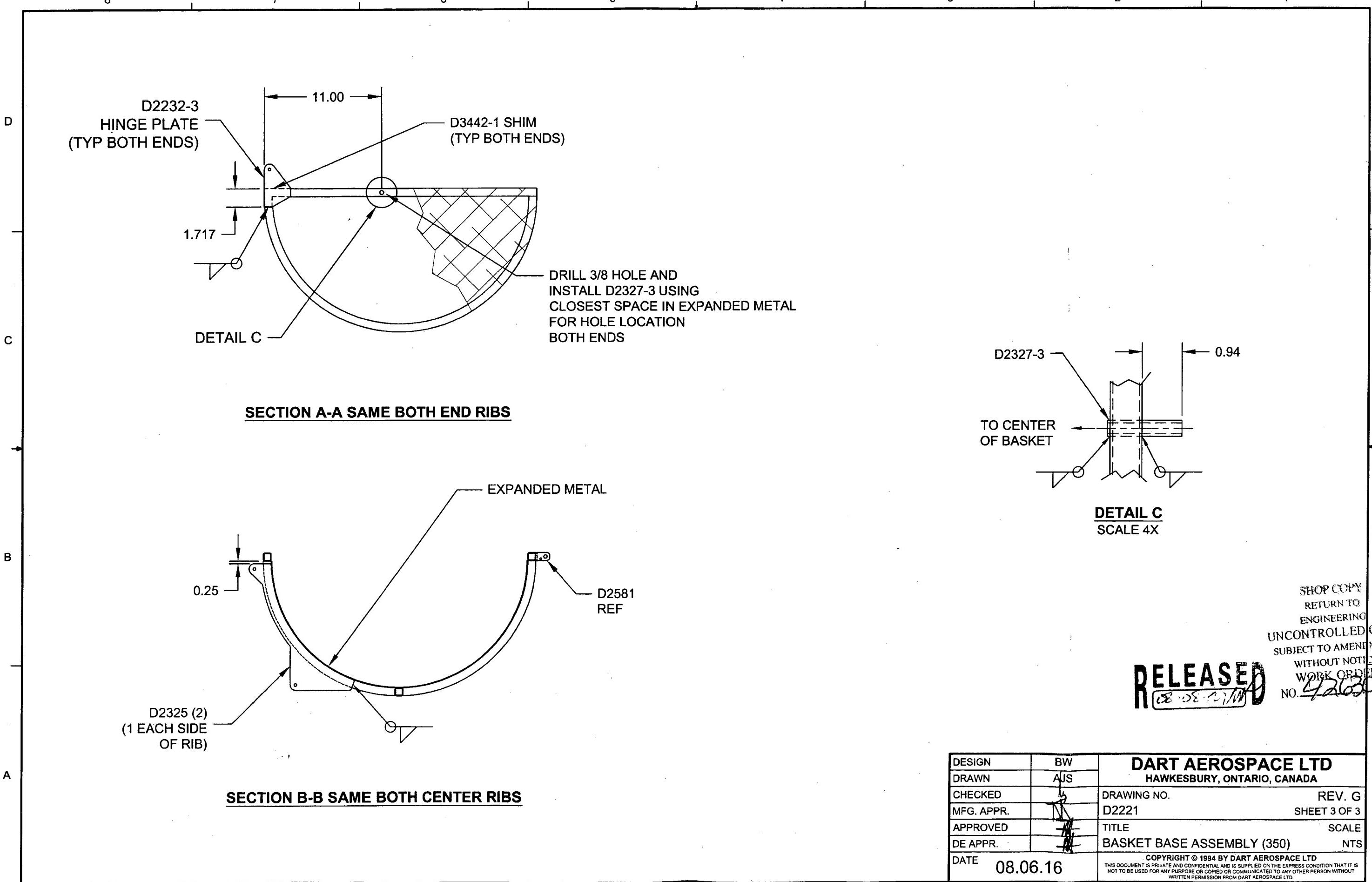
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NO. 620200  
06-28-21/H

G	MATERIAL FCR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B,5 TOLERANCE FOR 96.00 DIM WAS +/- 0.01, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF.NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPERATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> <b>HAWKESBURY, ONTARIO, CANADA</b>	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2221	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.06.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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DESIGN	BW	DART AEROSPACE LTD
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[initial]</i>	DRAWING NO. REV. G
MFG. APPR.	<i>[initial]</i>	D2221 SHEET 3 OF 3
APPROVED	<i>[initial]</i>	TITLE
DE APPR.	<i>[initial]</i>	SCALE
DATE	08.06.16	BASKET BASE ASSEMBLY (350) NTS

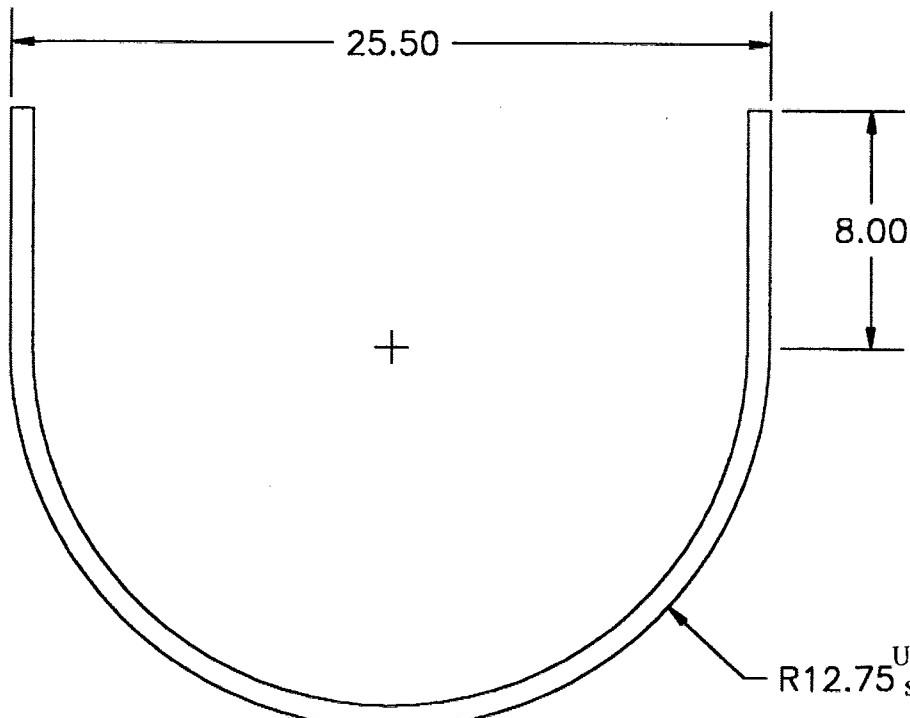
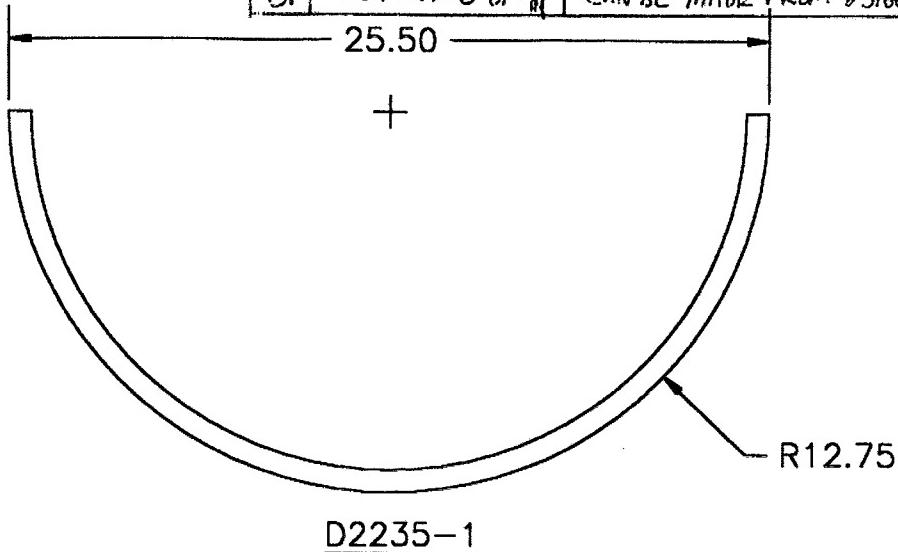
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**DART**

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
	BI 02.08.06 <i>U/H</i>	CAN BE MADE FROM D3166-1	

**RELEASED**  
R 960507



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NO. *10630*

CAN BE MADE FROM D3166-1 BI  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.